

Date: Thursday, 5/10/2007 2:09:08 PM
User: Kim Johnston

Process Sheet

SP/1/P

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L FLOAT STEP
Job Number : 32254	
Estimate Number : 10850	
P.O. Number : <i>N/A</i>	Part Number : D206628024
This Issue : 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : N/A
Previous Run : 26753	Material : <i>N/A</i>
	Due Date : 5/30/2007
Written By : <i>[Signature]</i>	Qty: <i>1/4</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG-002 *CZ*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	32254A	FLOAT STEP ASSEMBLY LH (206/407)
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Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B *32254A*

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D2731-7	Mounting Lug	<i>B29339 X</i>
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5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
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2	D2844-1	Arm	<i>B32284 ✓</i>
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7/6/21 se

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2844-3

Arm

129785 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total : 5.0639 f(s)

Pick :

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

132020 ✓

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASS,Y

1330998 ✓

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) +1

Pick:

Qty Part Number

Description

Batch

+1 3 AN3C4A

Bolt

1104214 ✓

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

1103691 ✓

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

119600 ✓

7/6/21 SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

4100447 ✓

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

4101067 ✓

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

4103962 ✓

15.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

4103691 ✓

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4 Nut (or MS21042-4)

4103715 ✓

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3 Washer

4100993 ✓

2/6/21 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *Q* Date: 07/06/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:09:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/6/21 (1) C2 07/06/21 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location:

PPP Rev:

PC 7/6/21 (1)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/06/21

Job Completion



U 07-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

206.628 024

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:09:26 PM
User: Kim Johnston

Process Sheet

shp 28/06

SP147

207-06-21

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32254A -2
Estimate Number : 11775
P.O. Number : N/A
This Issue : 5/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 31239ADrawing Name : FLOAT STEP ASSEMBLY (206/407)
Part Number : D2842042
Drawing Number : D2842 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 5/30/2007

Qty: 4 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev.D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part # Description Batch:
1 D2622-120C Extrusion B31984

Check Material for any Dents or Defects

H. 07.06.19

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 H. 07.06.19

2-Drill D2842-1 using Jig D28271 as per Dwg D2842 H. 07.06.19

3-Deburr and bevel ends for welding H. 07.06.19

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch:
2 D2734 End Cap B30883

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: B30909-4 B32292

H. 07.06.19

NIO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-21	8.0	Split for Qty 1 on this w/o = 3 on original	J	07-06-21	1	J 07-06-21	J 07-06-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

RH 2

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: 831238

RE 07-06-19 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

B

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842

A/R AL Rod Batch: M102756
M104305

RE 07-06-20 4

2-Grind end cap weld flush

PE 07-06-20 1
FF 07-06-20 3

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC5 6/20/06-20 (4)

QC9/AD 07-06-20 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

En 07/06/21 (1)
(X1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2006-21 (1)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

RE 07-06-21 1

2-Grind end cap weld flush.

U.M 07.06.20

G

Process Sheet

RH 2

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/21 RH ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-21 ①
RH

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

m 104144

M-L/BK

RH ①

07/06/21

14.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

m 100712

15.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

m 19522

16.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

m 104603

17.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

m 102473

FL 07/06/21 ①

Process Sheet

LA 2

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (286/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

m104733

FL/M-L

07/06/21 (1)

19.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

FL/07-06-21 (1)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP

B 32254

07/06/21 (1)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/21

Job Completion



U 07-06-21

DART**DART AEROSPACE USA, INC.**
PORT HADLOCK, WA

REV. B

SHEET 1 OF 1

DRAWING NO.
D2842TITLE
206L/407 FLOAT STEP ASSEMBLY

NTS

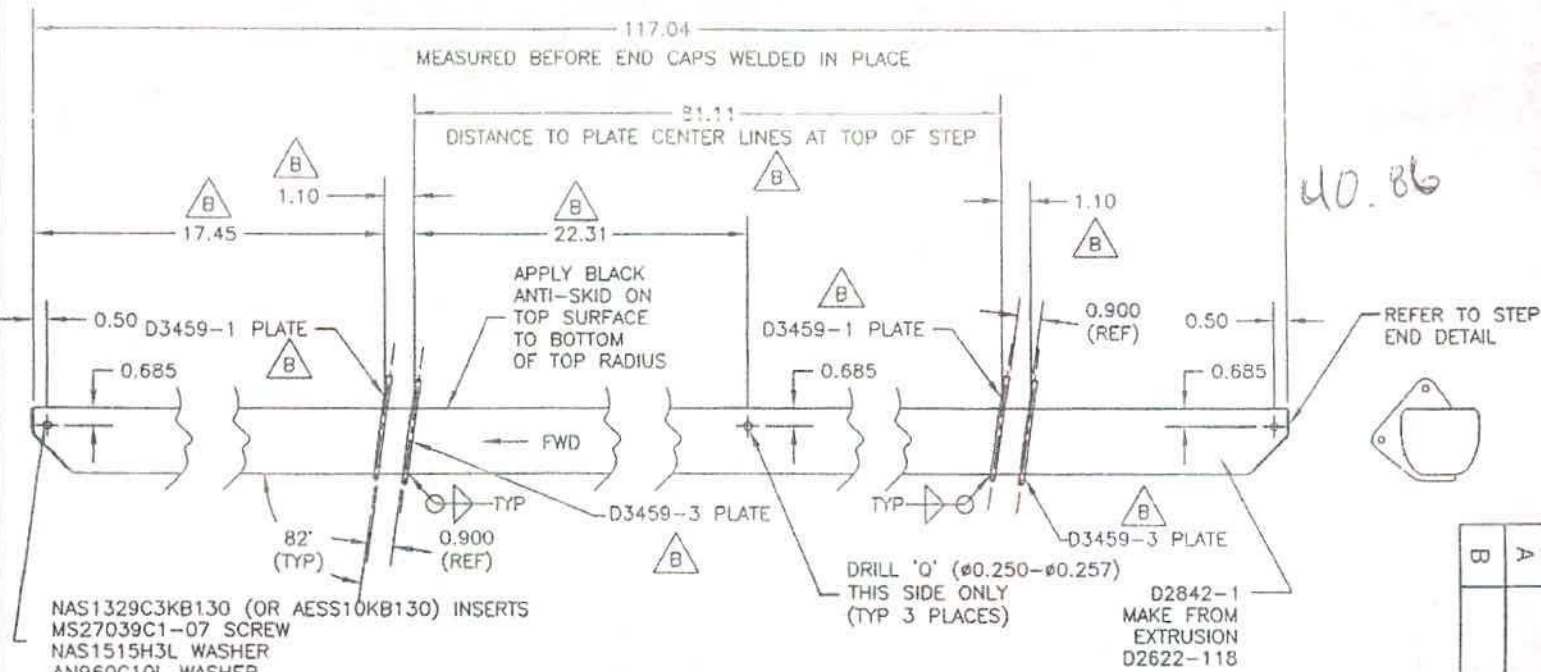
DATE
05.09.23CHECKED
*[Signature]*APPROVED
*[Signature]*DESIGN
KEDRAWN BY
PHDATE
05.09.23A
98.10.13

NEW ISSUE

B

05.09.23

RE-DESIGN, ADD D3459-1/-3



NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 32291A
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14